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-18-

ABSTRACT OF THE DISCLOSURE

A coated turning insert particularly useful for turning of forged components of stainless steel low alloyed steel. The insert is characterized by a WC-Co cemented carbide body having a highly W-alloyed Co-binder phase and a coating including an  
5 innermost layer of  $TiC_xN_yO_z$  with columnar grains and a top layer of fine grained  $\kappa$ - $Al_2O_3$ .